

Date: Monday, 5/1/2006 3:57:58 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW CAP
 Job Number : 26881
 Estimate Number : 10483
 P.O. Number : NIA Part Number : D3401041
 This Issue : 5/1/2006 S.O. No. : NIA Drawing Number : D3401 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 26590 Material : NIA
 Due Date : 5/25/2006 Qty: 12 Um: Each
 Written By : SAKIA COMMENT: Begun
 Checked & Approved By : JOHNSON.02
 Comment : Est. A 05.09.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R3500 Inventory



Comment: Qty.: 0.3675 f(s)/Unit Total: 4.4100 f(s)

Inventory

→ 7075-T651

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: M16548

M8 06/05/04

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks 4.200" long

M8 06/05/05 12

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: B

Dwg Rev: B

Deburr

B6 / M8 06/05/05

12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B6 / M8 06/05/05

12

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: AA

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

JL 06/05/14

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 06/05/14

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink' using DT8782 as per Dwg D3401

FF 06.05.25 10

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.05.25 (10)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/29 (12)

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/30 (12)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 06.05.30 (12)

12.0 NAS1330C3KB116 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Insert

Pick:

Qty Part number Description Batch

4 NAS1330C3KB116 Insert

M19349

Assemble as per Dwg D3401

Identify as D3401-041

DL 06/06/13 (12)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06 06 13 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FD 17

DL 06/06/13 (12)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/06/14 (12)

Job Completion



W 06/06/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

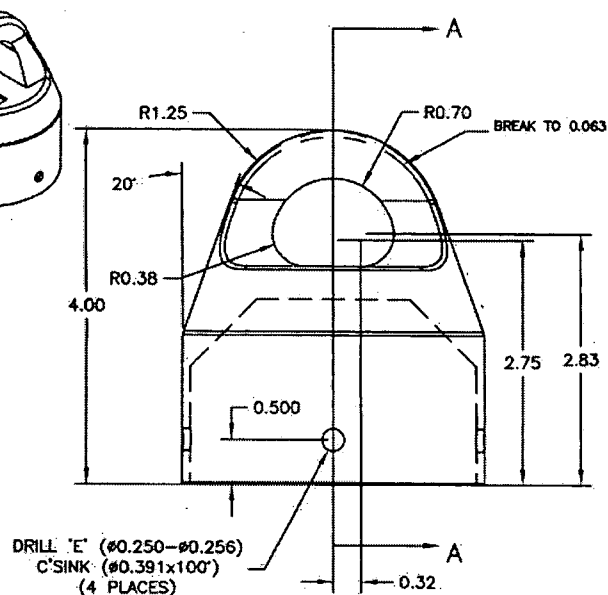
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

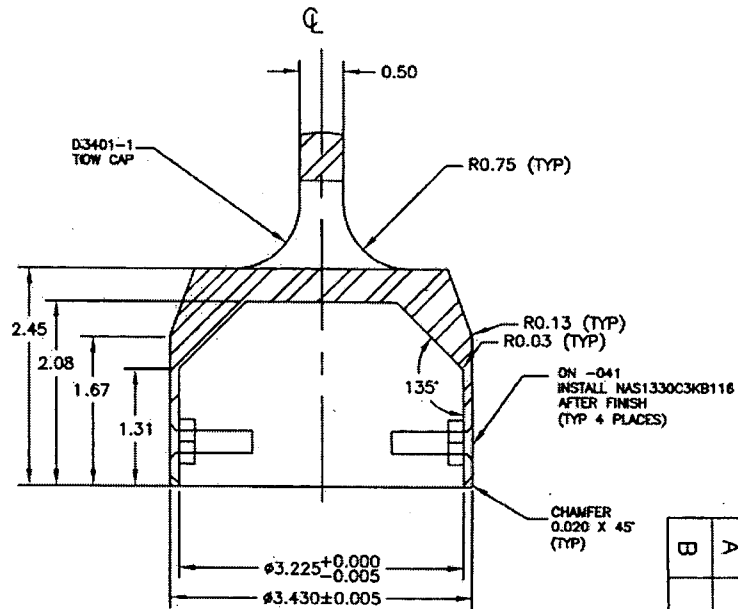
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

WORK ORDER
NO. 2688

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOP COPIES
RETURN TO
ENGINEERING

WORK ORDER

NO. 20801

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.		REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3401	SHEET 1 OF 1
DATE	05.06.09			TITLE	TOW CAP	
A	05.02.24			SCALE	1:2	
B	05.06.09			CHAMFER INSIDE, REMOVE RADIUS		

05-08-09 ~~11~~

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Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Friday, April 07, 2006 3:51 PM
To: Linda Lacelle
Cc: Bill Beckett; Peter Hum
Subject: Re: tow caps D3401-041

The 7075-T651 is an acceptable material substitution on the D3401-041 tow caps.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "*David Shepherd (E-mail)" <davids@dartaero.com>
Cc: "Bill Beckett (E-mail)" <billb@dartaero.com>; "Peter Hum (E-mail)" <peterh@dartaero.com>
Sent: Friday, April 07, 2006 1:22 PM
Subject: tow caps D3401-041

>
> We show stock on the 6061 round bar, but it is not...we have 7075-T651 in
> stock, and since we have so many tribeams sold, I'd like to know if we can
> use this, for this time only, while we wait for the other mat'l to come
> in.
> Please let me know asap, as I'd like to have these run on the wknd.
> Thx
> LL
>

